

# Work Order ID 86739

\*86739\*

Page 1

July-06-12 11:48:51 AM

Item ID: D3025-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Beam  
 Start Date: 7/06/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 7/06/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: H Date: 12079 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3025	B					4			

100 FLOW WATER JET 0.00  
 \*100\*  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg  
 Dwg Rev: B  
 Prog Rev: B  
 2-Deburr if necessary  
 110 QC2- Inspect parts off machine FAI/FAIB 0.00  
 \*110\*  
 QC Memo 0.00  
 Quality Control  
 120 QC8- Inspect parts - second check 0.00  
 \*120\*  
 QC Memo 0.00  
 Quality Control  
 4  
 SmB  
 12-7-24  
 DAS  
 16  
 9-8 12/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86739

\*86739\*

Page 2

July-06-12 11:48:52 AM

Item ID: D3025-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Beam

Start Date: 7/06/12 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 7/06/12 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Bend as per dwg

0.00

\*130\*

Brake NC

Memo

0.00

Brake NC

SP 12/08/15

QC 5 → SMB 12-8-13

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

Memo

0.00

Hand Finishing

BY TB 12-8-16

150

QC3- Inspect Part Finish

0.00

\*150\*

QC

Memo

0.00

Quality Control

12/8 /100P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 3

July-06-12 11:48:52 AM

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 Required Date: 7/06/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>177</u>	0.00	<u>5.1</u>	<u>2</u>		<u>12/08/16</u>			<u>40</u>
*160*									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

ML5 12/08/17  
 ML5 12/08/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

July-06-12 11:48:51 AM

Page 1

Work Order ID: 86739

Parent Item: D3025-1

Parent Item Name: Beam

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C01.10.26Added Bending as per Drawing. SM IPP REV:D 11.05.16 MAT'L  
THIKNESS CHG DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	213.4700	0.75	0.7894737	31	8-12-7-24	

Location

Loc Qty

Loc Code

MAT022

213.47

105411

6

109424

4

112331

3

113796

5

114025

10.7

116604

5.8

117392

19.1

118180

46

119117

25.7

120989

88.17

120 78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

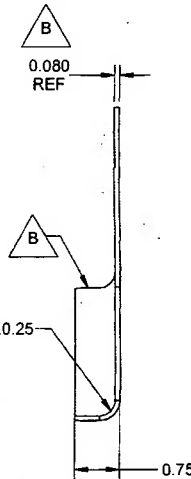
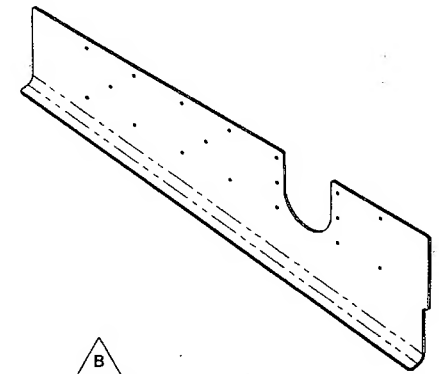
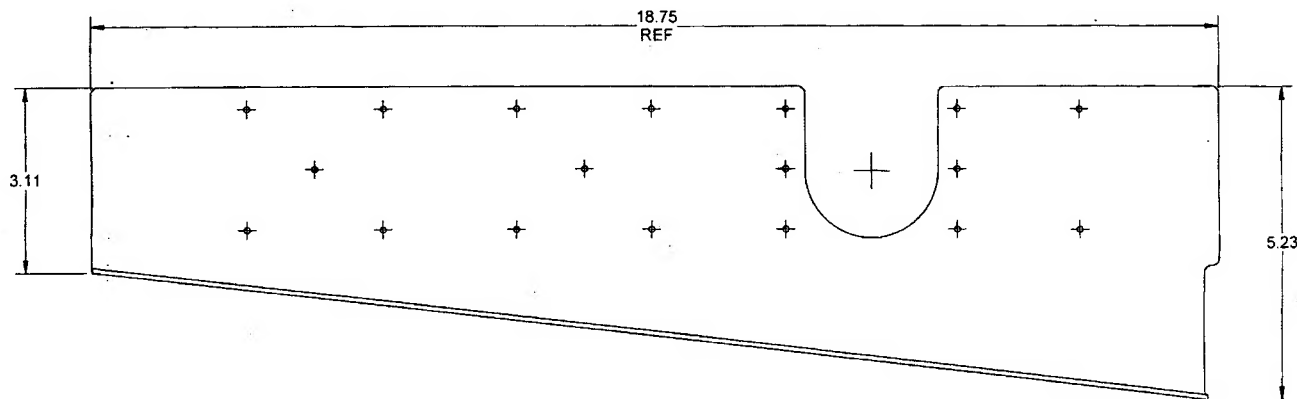
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**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86739 PL12-07-4



**D3025-1 BEAM**

**RELEASED**  
2011-05-18

**NOTES:**

- 1) MATERIAL: MAKE FROM D3025-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.67 lbs

B	5.78 WAS 6.564 (ZN B2-2); 0.080 WAS 0.050 (ZN C2-1 & B1-2); DIMENSIONS CHANGED TO 2 DEC PLACES; REVERSE BEND	RF	11.05.11
A	NEW ISSUE	RF	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3025	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BEAM	NTS
DATE	11.05.11	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

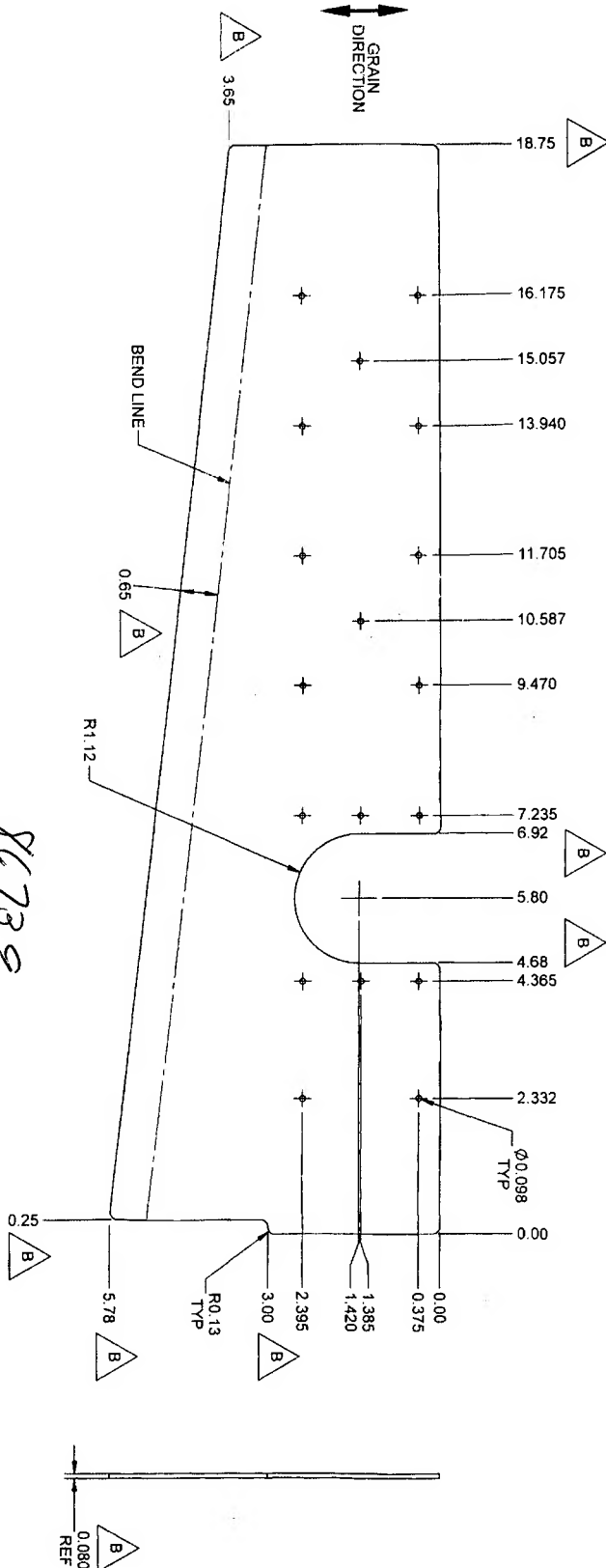
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**NOTE:** Date & initial all entries

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR ASTM B209  
REF DART SPEC M2024T3S.080
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.67 lbs

**D3025-1F FLAT PATTERN**

86730



DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	
MFG. APPR.	RF	D3025
APPROVED	RF	REV. B
DE APPR.	RF	SHEET 2 OF 2
DATE	11.05.11	SCALE
		NTS

RELEASED  
2011-05-18  
JND

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 86739
<b>Description:</b> BEAM	<b>Part Number:</b> D3028-1
<b>Inspection Dwg:</b> D3028-1 Rev: B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	± .004 - .007	.102	1		V B.C.2	
.25	± .02	.254	2		V	
5.78	± .030	5.760	1		V	
3.00	± .030	2.999	1		V	
2.395	± .010	2.400	1		V	
1.385	± .010	1.387	1		V	
.375	± .010	.378	1		V	
2.332	± .010	2.330	1		V	
4.365	± .010	4.370	1		V	
4.18	± .030	4.683	2		V	
6.92	± .030	6.916	1		V	
7.235	± .010	7.239	1		V	
9.470	± .010	9.470	1		T Bol	
10.587	± .010	10.587	1		T	
11.705	± .010	11.705	1		T	
13.940	± .010	13.940	1		T	
15.057	± .010	15.057	1		T	
16.175	± .010	16.175	1		T	
18.75	± .030	18.75	1		T	
<del>2.11</del>						
1.080	± .010	.0803	1		V	

<b>Measured by:</b> MB	<b>Audited by:</b> SMB	<b>Preliminary Approval:</b>
<b>Date:</b> 12-7-24	<b>Date:</b> 12-7-24	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	